

Date: Monday, 8/13/2007 2:14:59 PM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPAD
Job Number : 33881	
Estimate Number : 12711	
P.O. Number : N/A	Part Number : D35373
This Issue : 8/13/2007 S.O. No. : N/A	Drawing Number : D3537 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 33285	Material : N/A
Written By : <u>07-08-13</u>	Due Date : 8/20/2007 Qty: 60 Um: Each
Checked & Approved By : <u>07-08-13</u>	
Comment : Est Rev:A New Issue 07-02-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.1512 sf(s)/Unit Total : 9.0720 sf(s)
M304S16GA Stainless steel sheet 0.063" thick
Batch: 1109130

SAN 07/08/13

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3537
Dwg Rev: C
Prog Rev: C

2-Deburr if necessary

SAN 07/08/13

60

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAN 07/08/13

60

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 07/08/14

60 caen

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3
Form Joggle as per Dwg D3537 on brake using Jig DT8158

SAN 07/08/22
SAN 07/08/23

60
60

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33881

Part Number: D35373

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

QC5

INSPECT WORK TO CURRENT STEP



center

Comment: INSPECT WORK TO CURRENT STEP
Ensure joggle as per dwg D3429

En 07/08/23

(+60)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Qty Description Batch
A/R 2059B Hardcoat m105315/14105465
Weld hardcoat as per Dwg D3437

07/09/10

(60x)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/09/11 (60)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/09/11 (60)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m104846

07-09-12

(60)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m1 07 09 12

(60)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: F.P

m1 07 09 12

(60)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/13

(60)

Job Completion



07/09/13

DART AEROSPACE LTD		Work Order:	33881
Description: Wearpad		Part Number:	D3537-3
Inspection Dwg: D3537 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

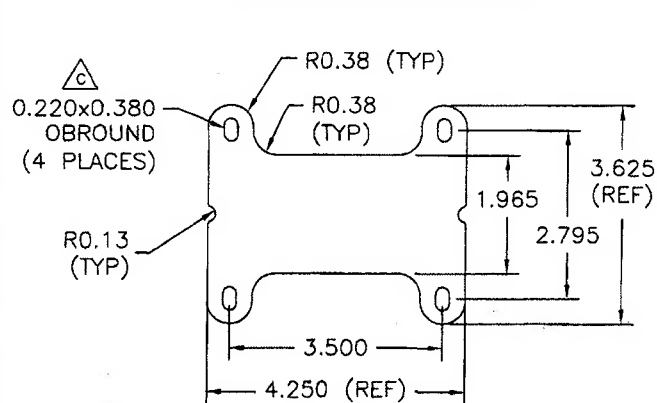
 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.859	+/-0.010	5.853	✓		Vern	
3.500	+/-0.010	3.501	✓		Vern	
1.965	+/-0.010	1.962	✓		Vern	
2.795	+/-0.010	2.798	✓		Vern	
3.625	+/-0.010	3.621	✓		Vern	
0.220 x 0.380	+/-0.010	0.220 x 0.380	✓		Vern	

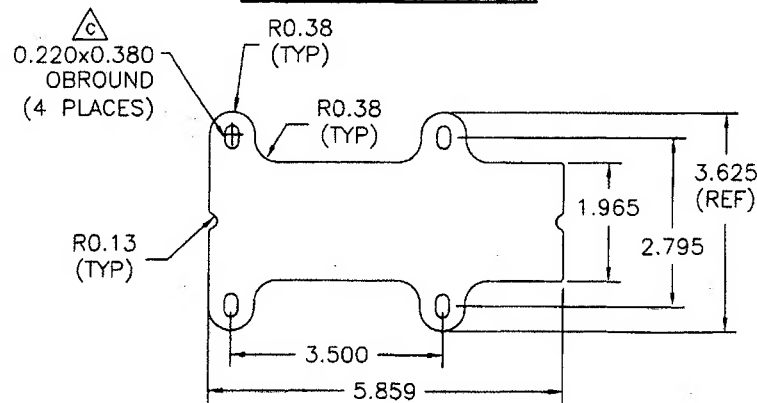
Measured by:	SAD	Audited by:	En	Prototype Approval:	N/A
Date:	07/08/13	Date:	07/08/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	EE

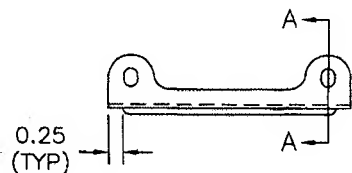
D3537-1F FLAT PATTERN



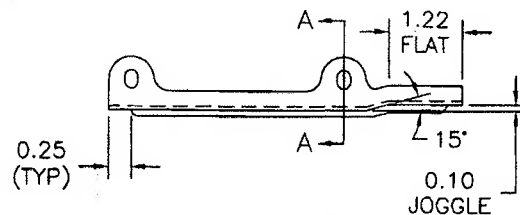
D3537-3F FLAT PATTERN



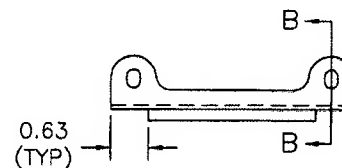
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



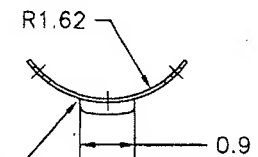
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

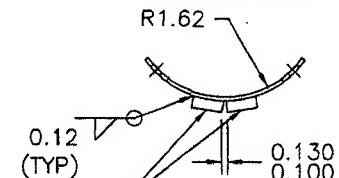
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SECTION A-A



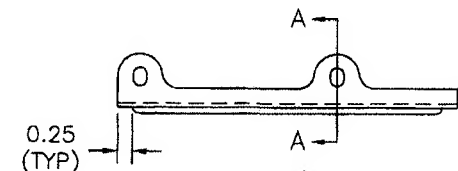
APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

SECTION B-B



D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



RELEASED
07-05-08 AM
per EGN
962

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DART AEROSPACE USA, INC.		REV. C
D3537		SHEET 1 OF 1
		SCALE 1:2

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